

Date: Tuesday, 9/4/2007 11:29:39 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLANGE PLATE
Job Number	: 34398		
Estimate Number	: 12235		
P.O. Number	: <i>N/A</i>	Part Number	: D34771
This Issue	: 9/4/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3477 REV A
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 31275	Drawing Revision	: A
		Material	: <i>N/A</i>
		Due Date	: 10/4/2007
Written By	: <i>[Signature]</i>	Qty:	6 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev: A New Issue 06-02-07 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M304S26GA	304/316 0.018 SHEET
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Comment: Qty.: 0.3707 sf(s)/Unit Total: 2.2239 sf(s)

304/316 0.018 SHEET

Batch: *M105490 HB 07-09-06*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

Cut as per Dwg D3477

Dwg Rev: *A*

Prog Rev: *A*

*HB 07-09-06*

*(6)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*HB 07-09-06*

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*can be*  
*cr 07/09/06* *(46)*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

*SAD 07/09/06* *(6)*

2-Form as per Dwg D3477 using Dt8858 A,B&C

*mf 07-12-13* *(6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: D Date: 01/12/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/4/2007 11:29:39 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE PLATE

Job Number: 34398

Part Number: D34771

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/12/18

(6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

mf

07-12-18

(6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2007/12/18

(6)

Job Completion



2007/12/18  
W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3477</b>	REV. A SHEET 1 OF 4
DATE <b>05.12.09</b>	TITLE <b>BLOWER INLET ADAPTER</b>		SCALE 1:2
A	05.12.09	NEW ISSUE	

*[Signature]* 06.04.03D3477-5 BLOWER  
ADAPTER FLANGE (1)D3477-3  
TUBE (1)D3477-1  
FLANGE (1)ALIGNMENT OF  
SPOT WELD SEAM $\phi 7.13$   
(REF)

30°

45°

30°

(2 PLACES)

 $\phi 0.50$   
(24)

2.04

**D3477-041 BLOWER MOTOR INLET ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3477-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3477-041	BLOWER MOTOR ASSEMBLY
1	D3477-1	FLANGE
1	D3477-3	TUBE
1	D3477-5	BLOWER ADAPTER FLANGE

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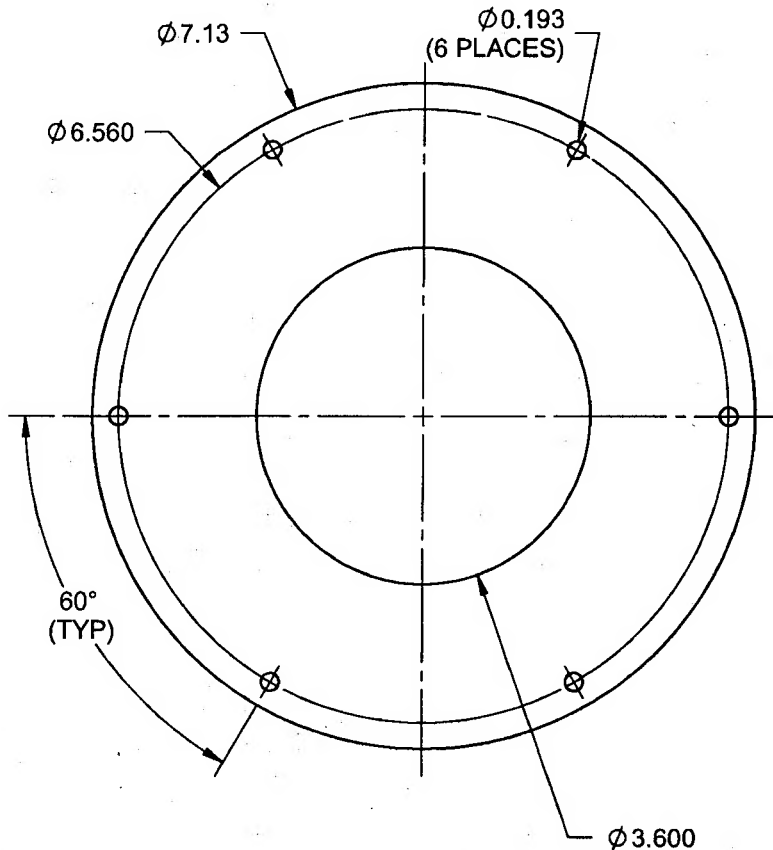
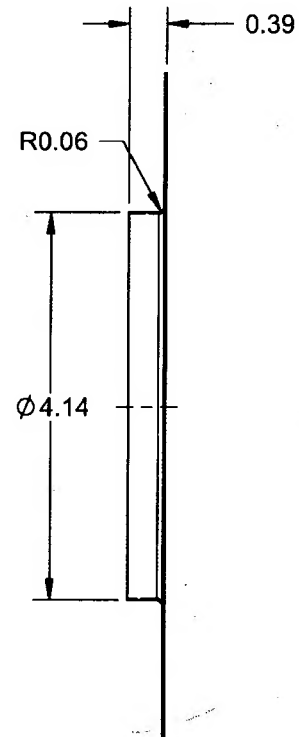
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DATE 05.12.09		TITLE BLOWER INLET ADAPTER	SCALE 1:2

# 06.04.03

**D3477-1F FLANGE  
FLAT PATTERN****D3477-1  
FLANGE****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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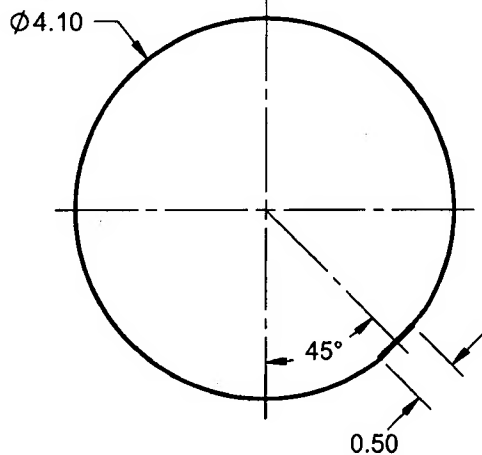
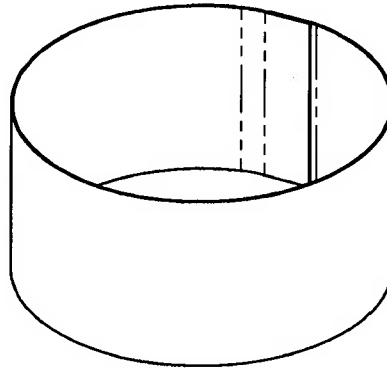
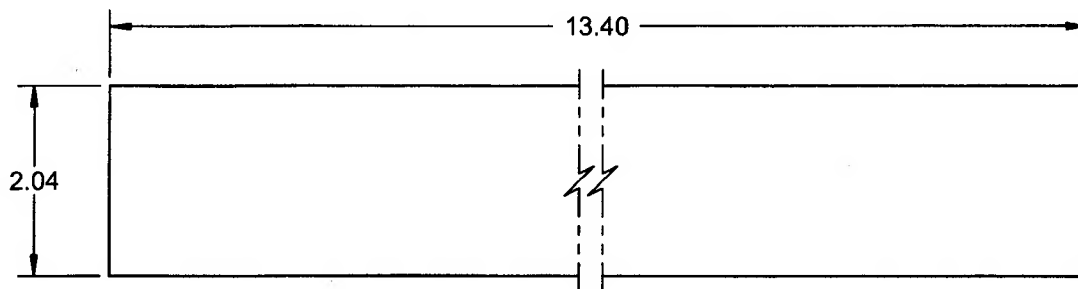
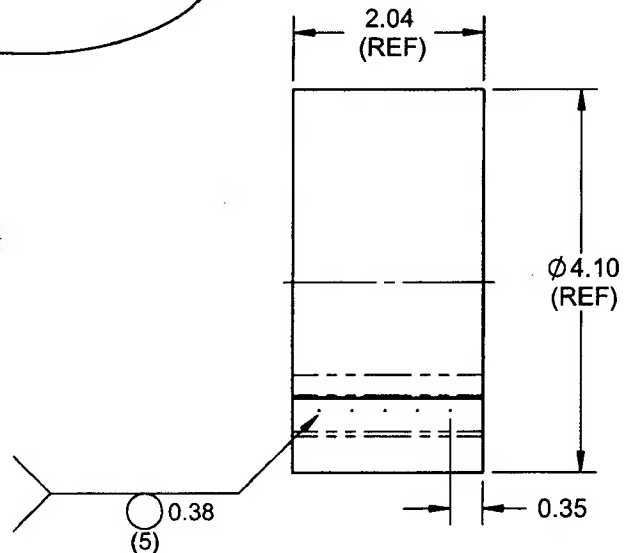
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DESIGN <i>B</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. <b>D3477</b>	REV. A SHEET 3 OF 4
DATE <b>05.12.09</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:2

*#* 06.04.03**D3477-3 TUBE****D3477-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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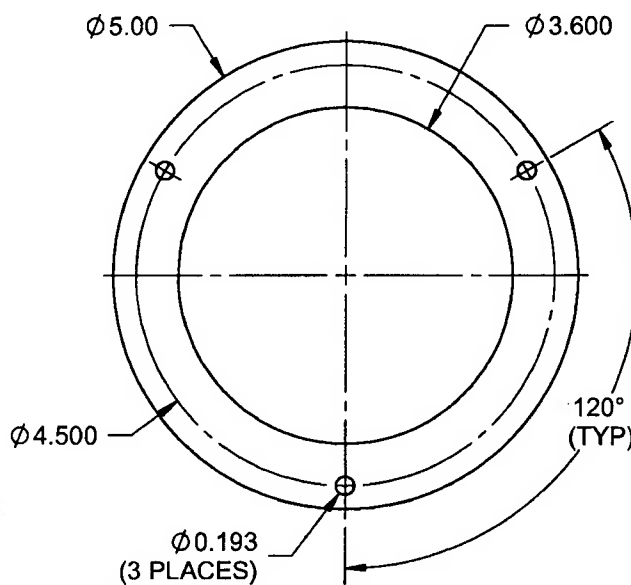
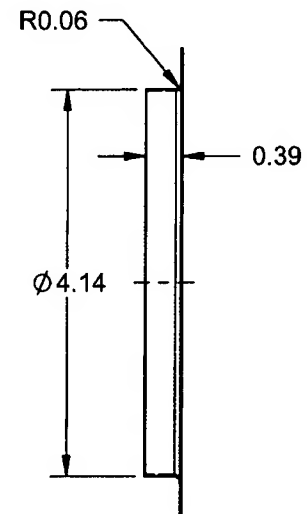
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DATE 05.12.09		TITLE BLOWER INLET ADAPTER	SCALE 1:2

# 06.04.03

**D3477-5F FLAT PATTERN****D3477-5 BLOWER  
ADAPTER FLANGE****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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